

# Work Order ID 115385

March-28-14 10:47:05 AM

**\*115385\***

Page 1

Item ID: D2896-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Support

Start Date: 3/28/14 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 4/11/14 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals: Process Plan: *MLS*

Date: *14-03-28* Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2896

C

100

0.00

**\*100\***

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Machine as per Folio FA167

Folio Rev: *AA*

Dwg Rev: *C*

Deburr

\*\*\*\*Program Batch #\*\*\*\*\*

110

QC1- Inspect dimensions to dimension sheet

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*DL 14.04.29*

*NY 17/05/06*

*20*

*MH 14/05/06*

*P10*

DQA:

Date:

14/06/03



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

14/5/23

Work Order update only ☐

Work Order: <u>115385</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D2896-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3896</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/4/29	100	1	3.50 dim is undersized.	DAS 12 9-89	SCRAP/Replace	14/05/23	14/05/19	DAS 16 9-89
Equip/Tooling						Critical surface			
Handling/Pre					14/4/29				14/04/29.
Material									
Operator	X								
Offset/Setup									
Process	X								
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input checked="" type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 115385

March-28-14 10:47:05 AM

**\*115385\***

Page 2

Item ID: D2896-1

Revision ID:

Item Name: Support

Start Date: 3/28/14

Required Date: 4/11/14

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

**\*NS1\***

**\*NS2\***

Run Start

Stop

**\*NR1\***

**\*NR2\***

Sequence ID/  
Work Center ID

120

**\*120\***

QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

*ml 14/05/19 20 0*

130

**\*130\***

Packaging

Packaging

Identify as per dwg & Stock Location: LG053

Memo

0.00

0.00

*20*

*CR 14-0520*

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*14/5/20*

*ml*

*14-5-20*

*Pto*

DQA:

Date:

14/06/03



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

14/5/23

Work Order update only ☐

Work Order: <u>115385</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D2896-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3897</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling	14/5/16	100	7	3.56 hole is up to 0.015" off from perpendicular.	DAS 12 889	Acceptable.	8/5/16		
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input checked="" type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

March-28-14 10:47:11 AM

Page 1

Work Order ID: 115385

\*115385\*

Parent Item: D2896-1

\*D2896-1\*

Parent Item Name: Support

Start Date: 3/28/14

Required Date: 4/11/14

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: B02.11.26Reformat: Added P/O: Added mask holeKJ

IPP Rev: C As per Rev B 07-04-16 JLM

IPP D 08.03.19 Re-format EC verified by DD

IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK080

Manufactured

No

100

Each

21.0000

0.5

10

\*\*

DAS  
02  
988

14-04-23

\*DSK080\*

D2896-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

21

103895

1

104458

20

X1  
X9 +1

DR 14.05.05

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115385
<b>Description: Support</b>		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg: D2896</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163		2.163	2.163	2.163
AB	2.340	2.360		2.357		2.351	2.354	2.354
AC	3.550	3.560				3.558	3.557	2.357
AD	3.770	3.790		3.783		3.788	3.784	3.781
AE	0.065 x 0.315	0.085 x 0.335		0.071325		0.071315	0.071315	0.071315
AF	1.42	1.48		1.435		1.445	1.445	1.450
AG	0.833	0.853		0.835		0.846	0.843	0.843
AH	0.240	0.260		0.250		R.250	R.250	R.250
AI	0.261	0.266		0.262		0.261	0.261	0.261
AJ	0.189	0.194		0.189		1.9995	0.189	0.189
AK	1.970	2.030		2.00		1.9995	1.9995	1.9995
AL	0.625	0.630		0.626		0.626	0.626	0.626
AM	101.75	105.75		103.75		103.75	103.75	103.75
AN	0.053	0.073		0.063		0.063	0.063	0.063
AO	0.926	0.946		0.930		0.945	0.945	0.937
AP								
AQ								
AR								

**Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"**

Accept/Reject	0.001	0.001	0.001	0.0015	0.000
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<b>Measured by:</b> MH/	<b>Date:</b> 11/04/28
<b>Audited by:</b>	<b>Date:</b> 14.04.30
<b>Preliminary Approval:</b>	<b>Date:</b> 14/05/17

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115385
<b>Description: Support</b>		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg: D2896</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6.4	72	83	94	10.5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.355	2.355	2.355	2.357	2.356
AC	3.550	3.560		3.554	3.554	3.558	3.554	3.556
AD	3.770	3.790		3.781	3.78	3.788	3.788	3.786
AE	0.065 x 0.315	0.085 x 0.335		0.07 x .315	0.07 x .315	0.07 x .35	0.07 x .315	0.07 x .315
AF	1.42	1.48		1.455	1.455	1.455	1.445	1.445
AG	0.833	0.853		.8425	.842	.842	.8425	.843
AH	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AI	0.261	0.266		Ø.261	Ø.261	Ø.261	Ø.261	Ø.261
AJ	0.189	0.194		Ø.189	Ø.189	Ø.189	Ø.189	Ø.189
AK	1.970	2.030		1.9995	2.000	2.000	2.003	1.993
AL	0.625	0.630		Ø.626	Ø.626	Ø.626	Ø.626	Ø.628
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	0.063
AO	0.926	0.946		.938	.94	.94	.94	.943
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				∞	.0025	.0005	.00025	.0005

<b>Measured by:</b>	MH	<b>Date:</b>	14/05/01/14.05.3
<b>Audited by:</b>	SM	<b>Date:</b>	14/05/14
<b>Preliminary Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115385
<b>Description: Support</b>		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg: D2896</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 1	1 2	1 3	1 4	1 5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.351	2.351	2.354	2.351	2.354
AC	3.550	3.560		3.554	3.552	3.5515	3.553	3.551
AD	3.770	3.790		3.784	3.784	3.788	3.788	3.778
AE	0.065 x 0.315	0.085 x 0.335		0.07315	0.07315	0.07315	0.07315	0.07315
AF	1.42	1.48		1.445	1.445	1.445	1.445	1.445
AG	0.833	0.853		.842	.842	.842	.842	.842
AH	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.189	0.189	0.189	0.189	0.189
AK	1.970	2.030		2.001	2.002	1.9995	1.999	1.996
AL	0.625	0.630		0.626	0.626	0.626	0.626	0.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.936	.937	.936	.939	.937
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				.0005	.001	.0015	.001	.001

<b>Measured by:</b> <i>DB</i>	<b>Date:</b> 14.05.03
<b>Audited by:</b> <i>amk</i>	<b>Date:</b> 14/05/19
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115385
<b>Description: Support</b>		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg: D2896</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 <sup>A</sup>	17 <sup>B</sup>	18 <sup>C</sup>	19 <sup>D</sup>	20 <sup>E</sup>
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.354	2.354	2.354	2.350	2.345
AC	3.550	3.560		3.550	3.551	3.551	3.557	3.555
AD	3.770	3.790		3.788	3.782	3.781	3.779	3.777
AE	0.065 x 0.315	0.085 x 0.335		0.072.315	0.072.315	0.072.715	0.07.315	0.072.315
AF	1.42	1.48		1.445	1.445	1.445	1.445	1.445
AG	0.833	0.853		0.842	0.842	0.842	0.842	0.842
AH	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.189	0.189	0.189	0.189	0.189
AK	1.970	2.030		1.9995	1.999	1.998	1.999	2.000
AL	0.625	0.630		0.626	0.626	0.626	0.626	0.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946						
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				1001	0015	00015	00005	001

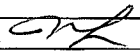
<b>Measured by:</b> DR/HH	<b>Date:</b> 14.05.04
<b>Audited by:</b> [Signature]	<b>Date:</b> 14/05/19
<b>Preliminary Approval:</b>	<b>Date:</b>

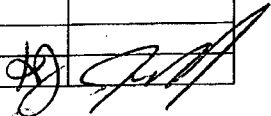
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	[Signature]

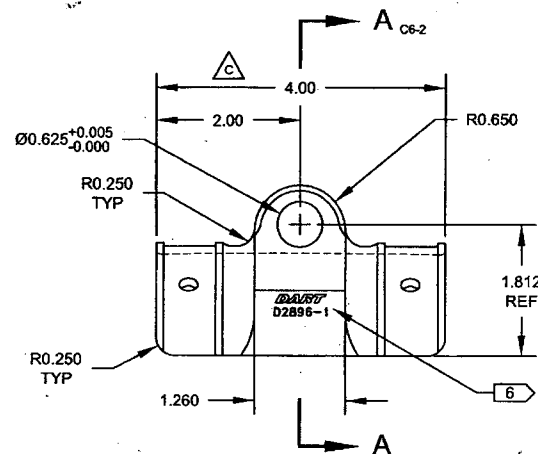
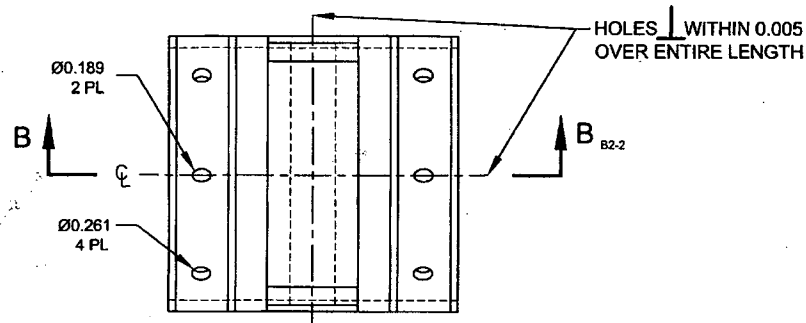
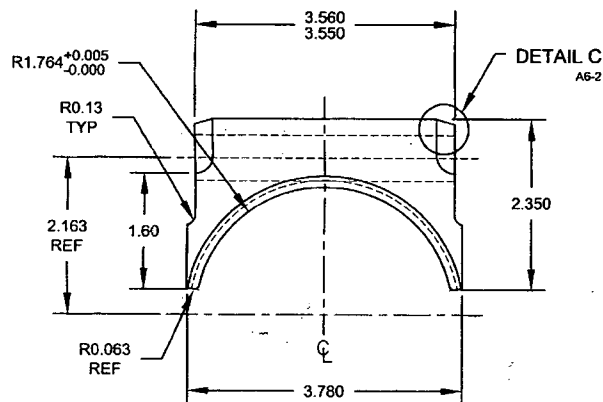
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115385
<b>Description: Support</b>		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg: D2896</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>HAAS Section</b>								
AA	2.152	2.172		2.163	2.163			
AB	2.340	2.360		2.345	2.356			
AC	3.550	3.560		3.558	3.558			
AD	3.770	3.790		3.782	3.782			
AE	0.065 x 0.315	0.085 x 0.335		0.085 x 0.325	0.075 x 0.325			
AF	1.42	1.48		1.43	1.43			
AG	0.833	0.853		.843	.843			
AH	0.240	0.260		.250	.250			
AI	0.261	0.266		Ø.262	Ø.262			
AJ	0.189	0.194		Ø.190	Ø.190			
AK	1.970	2.030		2.000	2.000			
AL	0.625	0.630		.627	.627			
AM	101.75	105.75		103.75	103.75			
AN	0.053	0.073		.063	.063			
AO	0.926	0.946		.943	.942			
AP								
AQ								
AR								
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>								
<b>Accept/Reject</b>				.001	.001			

<b>Measured by:</b> NH	<b>Date:</b> 14/05/06
<b>Audited by:</b> 	<b>Date:</b> 14/05/19
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
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F	12.07.31	Dimensions updated per Dwg Rev C	KJ	



**D2896-1 SUPPORT**

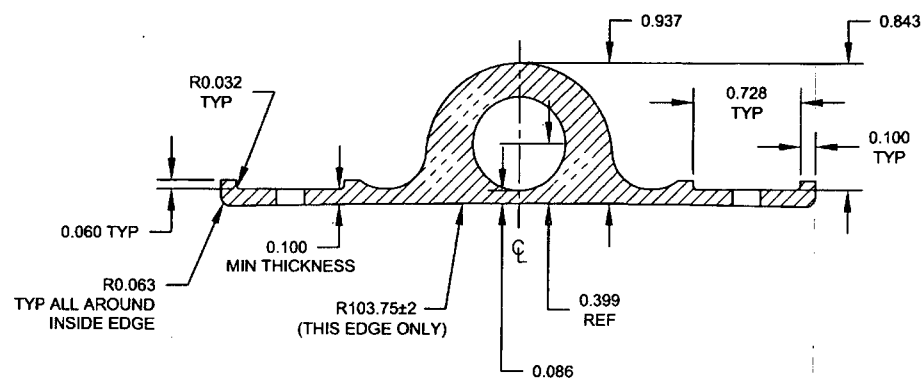
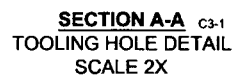
**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION PER ASTM A564 OR AMS 5643 OR AISI 630  
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
DESIGN	ASS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	D2896	SHEET 1 OF 2
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	




115385\_MLS  
14-03-28

**RELEASED**  
2011-09-29



**SECTION B-B** D3-1  
**SCALE 2X**

RELEASED  
2011-09-29

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D2896  TITLE SUPPORT  COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. C
DRAWN	90		SHEET 2 OF 2
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.07		NTS